

Date: Monday, 14/05/2007 3:07:35 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT CROSSTUBE		
Job Number	: 32346	Part Number	: D2890		
Estimate Number	: 10377	Drawing Number	: D2890 REV B		
P.O. Number	: N/A	Project Number	: N/A		
This Issue	: 14/05/2007	S.O. No.	: N/A	Drawing Revision	: B
Prsh't Rev.	: NC	Type	: PURCHASED PARTS		
First Issue	: N/A	Material	: N/A		
Previous Run	: 31371	Due Date	: 30/05/2007	Qty:	1 Um: Each
Written By					
Checked & Approved By					
Comment	: Est. 05.03.21 Removed Bending procedures KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6008180	Crosstube extrusion	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part # Description Batch 1 D6008-180 Crosstube extrusion 25667 EL 7-5-16			
2.0	BENDING	BENDING MACHINE	
Comment: BENDING MACHINE 1-Bend D2890 as per Dwg D2890 and Folio FT002 EL 7-5-16			
3.0	QC6	DIMENSIONAL CHECK	
Comment: DIMENSIONAL CHECK J0707.26 0			
4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
Comment: LANDING GEAR RESOURCE 1 N/A J			
1-Deburr and Polish			
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comment: HAND FINISHING RESOURCE #1 N/A J Chemical Conversion Coat as per QSI 005 4.1			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/17/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: AFT CROSSTUBE

Job Number: 32346

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



NRA J



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WIO 32357

J 207-26 ①

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

J 207-26 ①
J 207-27 ①

Job Completion



u 20827

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

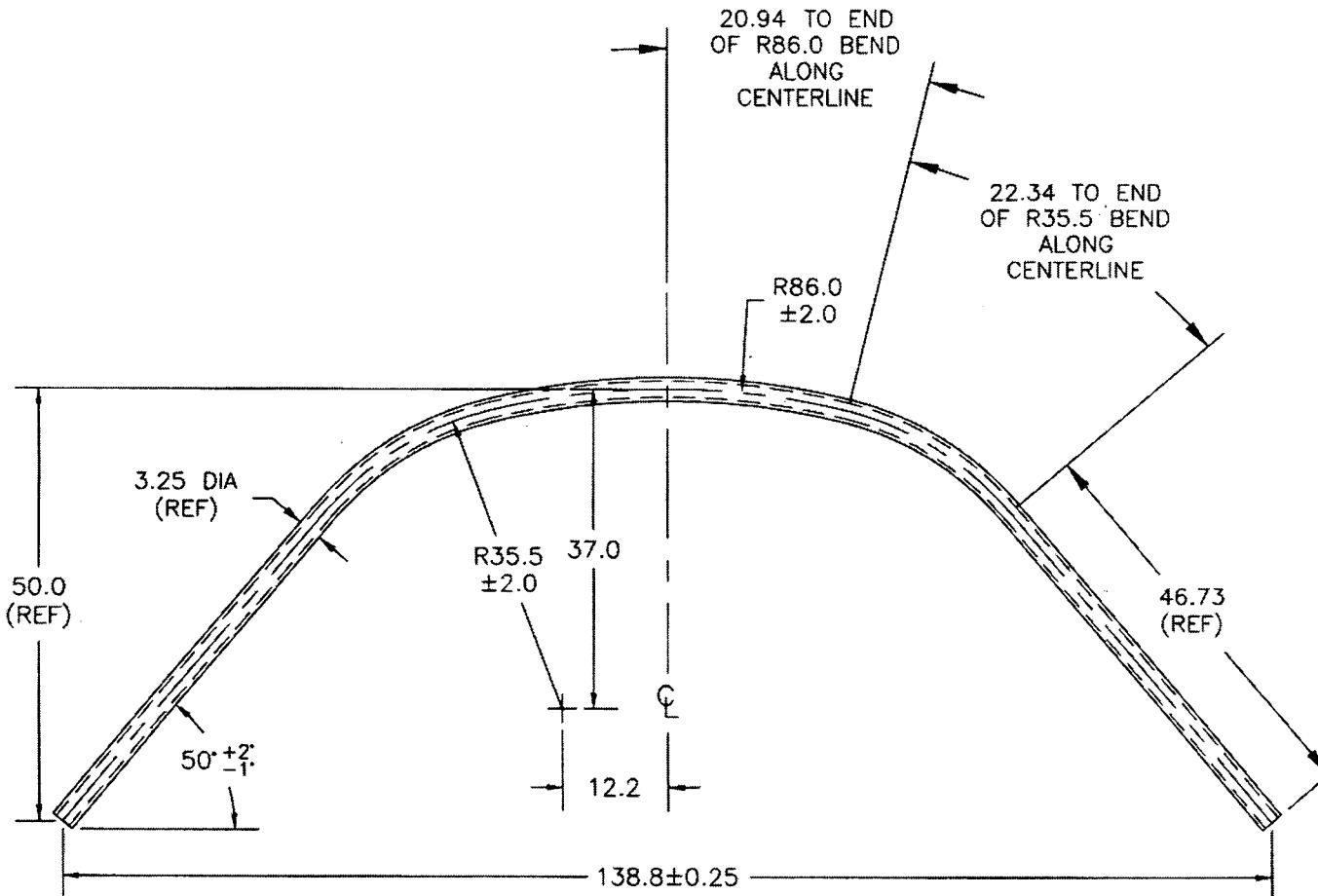
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART
RELEASED
 02-10-28

DESIGN	DRAWN BY	DART AEROSPACE LTD		
	IP	HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	REV. B		
	JP	DRAWING NO.	D2890	
DATE	TITLE	SHEET 1 OF 1		
02.10.18	AFT CROSSTUBE	SCALE	1:20	
A	99.05.21	NEW ISSUE		
B	02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES		

W/0 32346

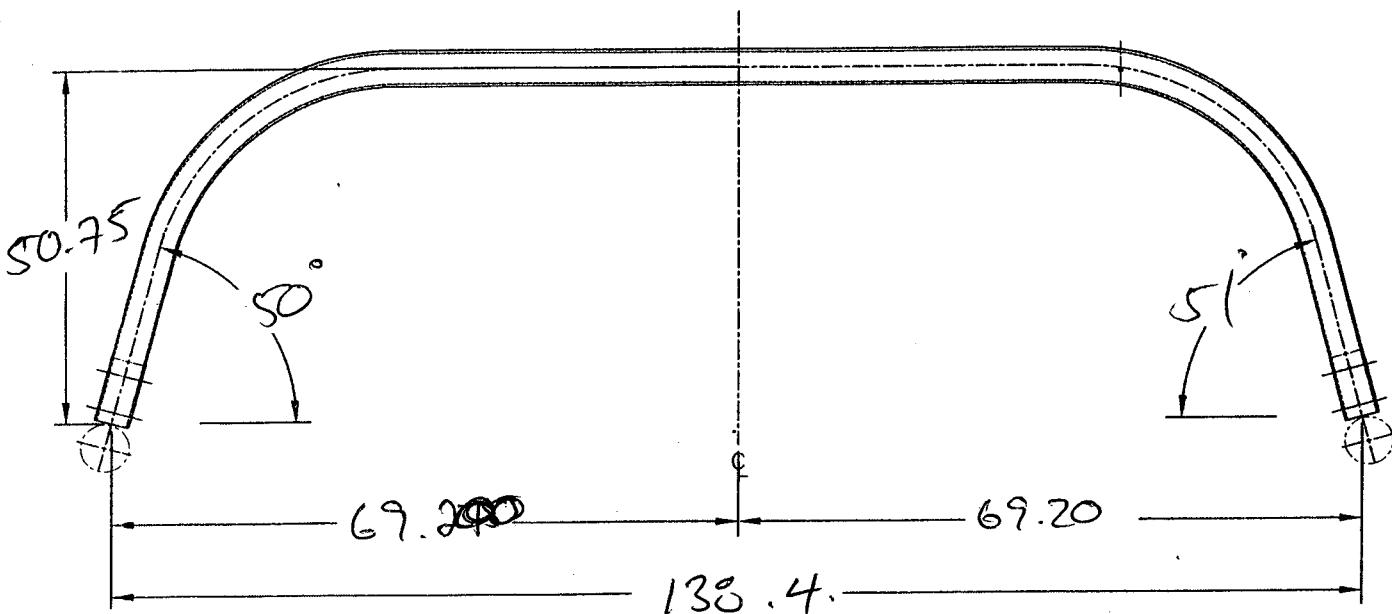
NOTES

- 1) MATERIAL: MANUFACTURE FROM D6008-180 ($\phi 3.25$ OD x 0.438 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.



DART AEROSPACE LTD	Work Order:	32346
Description: Crosstube Aft	Part Number:	D2890
Inspection Dwg: D2890	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
Tube is for -107 B32357 Acceptable. -107 dims are perfect.

QC15 Inspection	<i>J. Laskay</i>
Date	07/27/06

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>J. Laskay</i>